

Date: Monday, 12/01/2009 2:30:27 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TUBE ASSEMBLY
Job Number :	44561		
Estimate Number :	11527		
P.O. Number :		Part Number :	D3021041 <i>GY</i>
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3021 REVA
First Issue :	/ /	Project Number :	N/A
Previous Run :	44560	Drawing Revision :	A
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	10/02/2009
Written By :		Qty:	1
Checked & Approved By :	<i>JUD 09.01.12</i>	Um:	Each
Comment :	Est. 01.10.23 New Issue SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 RD Tube .750 x.049W
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Comment: Qty.: 2.1875 f(s)/Unit Total : 2.1875 f(s)
 4130 Tube .750 OD x.049W

Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall batch: *M11642*

material used from scraps from back frame assembly w/o 44559

RE 9-6-18

2.0	D301711	cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

cap
 batch: *B42354*

RE 9-6-18

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using D8622

3--Deburr

4-Weld as per Dwg D3021 QSI004

A/R 4130 Rod Batch: *M102226*

RE 9-6-18

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

RE 9-6-23

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:30:27 PM
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Drawing Name: TUBE ASSEMBLY

Job Number: 44561

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S0910663 (X)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 11:30am

OVEN TEMPERATURE: 320°F

FINISH TIME: 12:00pm

9/6/24 09-06-24 (X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-06-24

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/6/24

(R)

54

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24 (X)

Job Completion



C209106124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

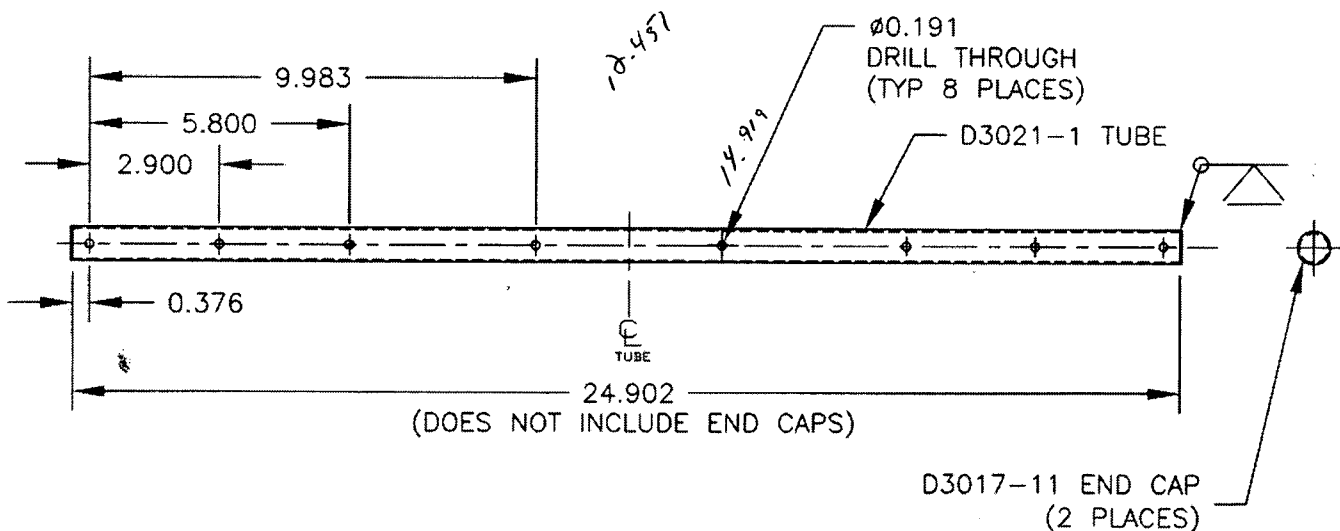
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>SP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, $\varnothing 0.75$ DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44561

RELEASED
01 05 30

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